

Work Order ID 154599

Thursday, December 15, 2016 1:34:02 PM

154599

Ship 6 JAN

Page 1

Item ID: D3823-1KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rear Overhead-LH

Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: DEC 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3823	Rev C

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DAS
07
9-89

16/12/20

105

0.00

105

HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

DAS
07
9-89

16/12/20

Temp: 150 deg. FTime IN: 5:00 PMTime OUT: 6:00 AM

DEC 20 2016

Per.

Work Order ID 154599***154599***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 9 9-89
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>PK</u> Memo	0.00 0.00							DAS 6 9-89
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							DAS 21 9-89

JAN 03 2017

JAN 06 2017

JAN 03 2017

Picklist Print

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Work Order ID: 154599

154599

Parent Item: D3823-1KIV

D3823-1KIV

Parent Item Name: Rear Overhead-LH

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased		No		100	sf	1,738.890	11.15	11.15558			DAS 07 9-89

MKYD6185S 080-P3-62015
Kydex Ivory (52"x96"-.080)

Location	Loc Qty	Loc Code
SHED	728	
m129761	347	
m130671	381	
therm	1010.89	
121755	13.44	
124462	997.45	

16/10/20. *Dr.*

11.1658 *BT*

DART AEROSPACE LTD		Work Order:	154595
Description: Rear Overhead, LH		Part Number:	D3823-1KIV/KGY
Inspection Dwg: D3823	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DAS 07 9-89	Date:	16/12/20
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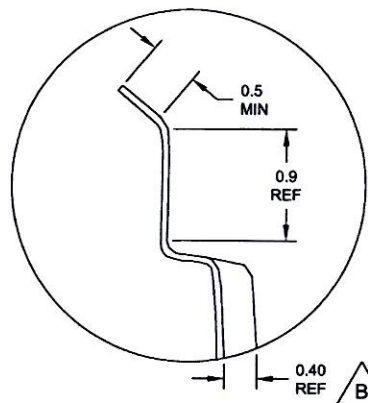
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.54"	✓			
0.44	Min	0.56"	✓			
1.75	Min	1.83"	✓			
0.045	Min	0.057"	✓			
0.055	Min	0.070"	✓			

Measured by:	DAS 07 9-89	Date:	16/12/22
Audited by:	9 9-89	Date:	16-12-22
Prototype Approval:	N/A	Date:	N/A

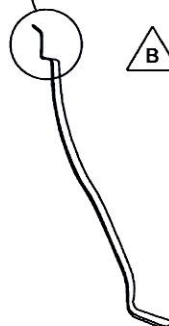
Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154599 KLS
1612-15



DETAIL B
SCALE 5X

SECTION A-A



0.44
MIN

B

B6-1

A

TEXTURED SIDE

35.94
REF

MIN THICKNESS
0.045
(SHADED REGION)

14.3
REF

1.75
MIN

RELEASED
9/27/05

D3823-1 REAR OVERHEAD, LH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

C
C

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3823-1/2-3(KIV) AND ADD STEEL GRAY P/N'S D3823-1/2-3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/2-3 FOR BETTER FIT WITH D3824-1/3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.29 (ZN B8-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3823 TITLE REAR OVERHEAD SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED	<i>PH</i>		
MFG. APPR.	<i>PH</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DATE	09.05.05		

A